

Date: Monday, 6/26/2006 2:39:12 PM
 User: Brenda Leonard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACER		
Job Number	: 27666		Part Number	: D30661		
Estimate Number	: 10383		Drawing Number	: D3066 REV. A		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 6/26/2006 S.O. No. : N/A		Drawing Revision	: A		
Prsh Rev.	: NC		Material	: N/A		
First Issue	: 6/26/2006 Type : MACHINED PARTS		Due Date	: 6/30/2006 Qty: 50 Um: Each		
Previous Run	: 27526					
Written By	: <u>See COMMENT below</u>					
Checked & Approved By	: <u>J</u>					
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.0992 sf(s)/Unit Total : 4.9613 sf(s)

Material: 6061-T6 0.080" thick

(M6061T6S.080)

Batch: M101178

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3066

Dwg Rev: AProg Rev: A

M.F. 06-07-06.

SAD 06:06:27

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:06:27 50

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

06.06.26

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 27666

Part Number: D30661

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06-07-08

50

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Z 06-07-10

30

Comment: INSPECT CHEMICAL CONVERSION COAT

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Z 06-07-10 (50)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06-07-10

Job Completion



U 06-07-10

Dart Aerospace Ltd.

Date: 6/23/2006 7:33AM
 User: Kim Johnston

PROCESS SHEET

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SPACER
Job No.	27666	Part No.	D30661
Estimate No.	10383	Drawing No.	D3066 REV. A/B
P.O. No.		Drawing Rev.	X/B
First Issue	SO No.	Project No.	
Prsht Rev.	11	Material	N/A
This Issue	NC	Due Date	6/30/2006
Prev. Run	6/23/2006	QTY:	50
	27526		

Written by:

Checked & Approved by:

Comment :

Est: *06.06.23* 02.11.01 Incorporated D3066-1 IPP KJ/RF

Job Number:



Seq. No.	Machine or Operation	Description
1.0	M6061T6S080	6061-T6 .080 Sheet
		Comment: Qty.: 0.0992 sf(s)/Unit Total : 4.9613 sf(s) Material: 6061-T6 0.080" thick (M6061T6S.080) Batch: _____
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3066 Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	QC5	INSPECT WORK TO CURRENT STEP
		Comment: INSPECT WORK TO CURRENT STEP
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/27/10	20	TIP was too large on the machine, causing 0.128 to be oversized.	CP 06/27/10 per QS1042	Change tip: scrap! replace parts. Qty 5	06/27/10 SAB	✓ 06/28	CP 06/27/10 per QS1042	J 06/27

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Number:



Seq. No.	Machine or Operation	Description
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT CHEMICAL CONVERSION COAT	
8.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location:	
9.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Inspection Level 21	

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

D3065-5DART AEROSPACE LTD	Work Order:	27666
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066	Rev: <i>KB</i>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Script \Rightarrow replace

Measured by: <u>SAD</u>	Audited by: _____	Prototype Approval: N/A
Date: <u>06/06/27</u>	Date: _____	Date: N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	P/O D3065-041	KJ/RF

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. B D3066
DATE	06.05.29	TITLE SPACER SCALE 1:3

A	02.09.11	NEW ISSUE
B	06.05.29	ADD 6061-T6 MATERIAL

RELEASED06.06.20 *ff**Ø 0.128 (#30)
(TYP 8 PLACES)***D3066-1 SPACER**

1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080) TOP COPY
RETURN TO
ENGINEERING
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK UNCONTROLLED COPY
SUBJECT TO AMENDMENT
(REF DART SPEC. M5052H32S.080) WITHOUT NOTICE
WORK ORDER

2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) BREAK ALL SHARP EDGES 0.005 TO 0.010
4) PART IS SYMMETRIC ABOUT CENTERLINE
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

NO. *27666*

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DART AEROSPACE LTD	Work Order:	27666
Description:	Part Number:	D3066-1
Inspection Dwg: , Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by: <u>SAD</u>	Audited by: <u>J</u>	Prototype Approval: <u>NA</u>
Date: <u>06/06/22</u>	Date: <u>06-06-22</u>	Date: <u> </u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	